



Dart Aerospace Ltd.
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647.7714
Job Sheet 170488



Part No: 647.7714

Job Qty: 16 ea

Part Name: Strut Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 1/24/18

Type: SOLD

Description:

Note: DWG REV A1 IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea		1/24/18	0.00	0.00	Start Up Machining-1		J.C. - L.
110	Mill Conv	16 pcs		1/24/18	0.00	2.88	Mill Conv 1		J.C. - L.
120	QC	16 pcs		1/24/18	0.00	0.00	QC2 Machining-1		J.C. - L. 18-01-29
125	QC	16 pcs		1/24/18	0.00	0.00	QC8 Machining-1		J.C. - L. 18-01-30
130	Packaging	16 pcs		1/24/18	0.00	0.00	Packaging3-1	LACV	JAN 31 2018
140	QC21-SA	16 Ea		1/24/18	0.00	0.00	QC21		JAN 31 2016

Part Op 110 - 1- CUT AS PER DWG
Descriptions: 130 - ***Stock in large fab*** WA001

DAS
21
2.9

JAN 31 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M4130NT0.500W.083	10	23	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Tube	6.500inches $\pm$ 0.005	6.505 6.495		6.500
2	Strut Tube	0.188inches $\pm$ 0.005	0.193 0.183	Radius	0.1875
3	Strut Tube	0.500inches $\pm$ 0.005	0.505 0.495	Diameter	0.500
4	Strut Tube	0.334inches $\pm$ 0.005	0.339 0.329	Diameter	0.333

Plex 1/16/18 2:30 PM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation		Disposition			Completed By		
					Lead hand / Supervisor Approval Verification		

Root Cause		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : _____

Job No: 170488

Start up Operation 01/29/18

Change No:

Operation:

Revision:

PART NO: 647.7714

Original Serial #: S036563

Strut Tube

S036563

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